

(19) World Intellectual Property  
Organization  
International Bureau



(43) International Publication Date  
22 January 2004 (22.01.2004)

PCT

(10) International Publication Number  
**WO 2004/007182 A1**

(51) International Patent Classification<sup>7</sup>: **B29C 69/00**,  
69/02, 65/02

(21) International Application Number:  
PCT/EP2003/007353

(22) International Filing Date: 9 July 2003 (09.07.2003)

(25) Filing Language: English

(26) Publication Language: English

(30) Priority Data:  
102 31 866.2 12 July 2002 (12.07.2002) DE  
60/416,990 8 October 2002 (08.10.2002) US

(71) Applicant (for all designated States except US): **BASELL  
POLYOLEFINE GMBH** [DE/DE]; Brühler Strasse 60,  
50389 Wesseling (DE).

(72) Inventors; and

(75) Inventors/Applicants (for US only): **ROHDE, Wolf-  
gang** [DE/DE]; Fritz-Ober-Strasse 21, 67346 Speyer  
(DE). **MEYER, Jörg** [DE/DE]; Mutterstadter Strasse 33,  
67125 Dannstadt-Schauernheim (DE). **SATTEL, Rainer**  
[DE/DE]; Richard-Wagner Strasse 6, 67165 Waldsee (DE).  
**SCHNORR, Jörg** [DE/DE]; Magdeburger Strasse 36,  
67071 Ludwigshafen (DE). **SPRINGHOLZ, Bernhard**

[DE/DE]; Waldprechtsstrasse 59, 76316 Malsch (DE).  
**WEINLEIN, Roger** [DE/DE]; Neue Kräme 27, 60311  
Frankfurt (DE). **WÜST, Andreas** [DE/DE]; Bleichstrasse  
20, 64673 Zwingenberg (DE).

(81) Designated States (*national*): AE, AG, AL, AM, AT, AU,  
AZ, BA, BB, BG, BR, BY, BZ, CA, CH, CN, CO, CR, CU,  
CZ, DE, DK, DM, DZ, EC, EE, ES, FI, GB, GD, GE, GH,  
GM, HR, HU, ID, IL, IN, IS, JP, KE, KG, KP, KR, KZ, LC,  
LK, LR, LS, LT, LU, LV, MA, MD, MG, MK, MN, MW,  
MX, MZ, NO, NZ, OM, PH, PL, PT, RO, RU, SC, SD, SE,  
SG, SK, SL, TJ, TM, TN, TR, TT, TZ, UA, UG, US, UZ,  
VC, VN, YU, ZA, ZM, ZW.

(84) Designated States (*regional*): ARIPO patent (GH, GM,  
KE, LS, MW, MZ, SD, SL, SZ, TZ, UG, ZM, ZW),  
Eurasian patent (AM, AZ, BY, KG, KZ, MD, RU, TJ, TM),  
European patent (AT, BE, BG, CH, CY, CZ, DE, DK, EE,  
ES, FI, FR, GB, GR, HU, IE, IT, LU, MC, NL, PT, RO,  
SE, SI, SK, TR), OAPI patent (BF, BJ, CF, CG, CI, CM,  
GA, GN, GQ, GW, ML, MR, NE, SN, TD, TG).

**Published:**

— with international search report

For two-letter codes and other abbreviations, refer to the "Guid-  
ance Notes on Codes and Abbreviations" appearing at the begin-  
ning of each regular issue of the PCT Gazette.

(54) Title: MULTISTAGE PROCESS FOR PRODUCING HOLLOW PLASTIC ARTICLES FROM HALF SHELLS

(57) Abstract: The present invention relates to a multistage process for producing hollow plastic articles, encompassing the follow-  
ing steps: a) producing a tubular plastic parison by means of extrusion or coextrusion; b) cutting open the plastic parison to produce  
two planar-surface parts; c) molding the planar-surface parts in two mold halves to give half shells, where a removable intermediate  
frame separates the mold halves from one another at least along the peripheral edges, so that the semifinished products/half shells  
are not in contact with one another; d) opening the mold halves and removing the intermediate frame; e) closing the mold halves,  
with the result that the half shells come into contact with one another along a peripheral rim; and f) bonding the half shells to give  
a hollow article.

WO 2004/007182 A1